

Work Order ID 110471

\*110471\*

Page 1

December-20-13 9:06:48 AM

Item ID: D135-751-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube (Fits LH or RH)

Stop \*NS2\*

Start Date: 12/20/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-12-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	DAS
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D3507	Rev <u>AD</u>	10 9-89
-------	---------------	------------

100

0.00

DAS  
6  
9-89

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo M. AD.  
Photocopy bluefile & type labels per PPP D135-751-011

CHG002

14-1-31

Document Control

mmh



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Start Date: 12/20/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

\*120\*

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. \*\*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297"

9-Open ground wire hole .297" section E-E

10-Open Aft & Fwd Cap holes using .208" drill.

11-Bore out aft end of tube as per Dwg D3507 & Detail "B".

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

mm 14/01/10

DC 14/01/14



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## Quality Control



14-1-14

22/4/01/14




14-1-14



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Stop \*NS2\*

Start Date: 12/20/13 Start Qty: 1.00

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Required Date: 1/03/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

\*170\*

Skidtubes

Skidtubes

0.00

Memo

1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507.  
and section G-G to .750" (2 places)

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 127097  
Exp Date: 12/08/16  
start time: 4:30  
end time: 14:01/16

5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G

A/R AL ROD Batch: M122324

6-Grind welds flush DG 1401-16

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

DE 14/01/14

BE 14/01/16

- DE 14/01/16





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**Stop** **\*NR2\***

[illegible]

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

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Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210	Pressure Wash per QSI005 4.3	0.00							
<b>*210*</b>	HandFinish								
Hand Finishing	Memo	0.00							
	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

1 76 14-1-22

220 *Spray paint* ~~White Gloss (Ref 4.2.5.1) per QSI005 4.3 Alum~~ 0.00

<b>*220*</b>									
<del>Powder Coat</del>									
<del>Powder Coating</del>	DAS	Memo							
	10								
	9-89								
		START TIME:							
		OVEN TEMPERATURE:							
		FINISH TIME:							

*① prime and paint as per dwg*  
*primer Batch: 126543*  
*paint Batch: 128009*

1 0 0 A8  
14-1-26

230 QC3 Inspect Part Finish 0.00

<b>*230*</b>									
QC									
Quality Control	DAS	Memo							
	10								
	9-89								

*5m*  
*14/1/28*

1 \_\_\_\_\_

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Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
<b>*260*</b>	HandFinish								
Hand Finishing	Memo	0.00							
	✓ 1- Install Wearplate & Ground Wire inserts as per Dwg D3507.								
	✓ 1-Inspect for Foreign objects								
	2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"								
	✓ A/R 241 Sika Flex Batch: <u>111127097</u>								
	Exp Date: <u>12/08</u>								
	✓ 3-Install Wearplates as per Dwg D3507,								
	Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube								
	Do not Install Screws where indicated on Dwg (Note #6)								
	✓ A/R 241 Sika Flex Batch: <u>111127097</u>								
	Exp Date: <u>12/08</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	✓ A/R 55-o'ring lube batch: <u>111121651</u>								
	5- Wing Walk as per Dwg D3507 and QSI 005 4.4								
	Batch: <u>11116051</u>								

1x 1/104/29

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**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**\*1\***

**Cust Item ID:**

**Start Date:** 12/20/13      **Start Qty:** 1.00

**Required Date:** 1/03/14      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270 QC5- Inspect part completeness to step on W/O

0.00

**\*270\***

0.00

QC

## Memo

## Quality Control

280	Pick Kit	0.00
-----	----------	------

**\*280\***

0.00

### Packaging

## Memo

## Packaging

290	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

\*290\*

0.00

QC

## Memo

## Quality Control



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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300		0.00			DAS				DAS
<b>*300*</b>	Packaging				31	14-2-5			6
Packaging	Memo	0.00			9-80				2-23
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>071</u>								
	PPP Rev: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
<b>*310*</b>									14-02-5
QC	Memo	0.00							
Quality Control									

14-02-5



# Picklist Print

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**\*D135-751-011\***

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E  
 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F 10.06.09  
 remove seq110 DD verf:EC IPP Rev G 10.09.17 added  
 D3507-1-bent EC verified by:DD IPP REV:H 13.12.11 ECN13-619/  
 CHG002 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

Each

2,112.000

38

**\*AI S7-1032-130\***

**\*\***

Rivnut

Location

Loc Qty

Loc Code

FG

100

121444

100

ST279

2012

119530

73

122763

38

124226

50

m126109

1851

x 38

D3507-1-BENT

Manufactured

No

120

Each

6.0000

1

1

**\*D3507-1-BFNT\***

**\*\***

Skidtube Assembly EC135

Location

Loc Qty

Loc Code

LG002

6

102577

2

104673

2

104674

2

(1)

mm 14/01/10



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**\*D135-751-011\***

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 22.0000 2 2

**\*D3504-1\***

Crossbolt Spacer

**\*\***

BE 14/01/14

Location

Loc Qty

Loc Code

LG001

22

99007

22

D3504-3 Manufactured No

170 Each 66.0000 1 1

**\*D3504-3\***

Crossbolt Spacer

**\*\***

BE 14/01/14

Location

Loc Qty

Loc Code

LG001

66

105604

53

31232

11

82726

2

D3504-5 Manufactured No

170 Each 25.0000 2 2

**\*D3504-5\***

Crossbolt Spacer

**\*\***

BE 14/01/14

Location

Loc Qty

Loc Code

LG001

25

106024

25

D3505-1 Manufactured No

170 Each 3.0000 1 1

**\*D3505-1\***

Web

**\*\***

DE 14/01/14

Location

Loc Qty

Loc Code

LG002

3

106459

3

1



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**\*D135-751-011\***

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3506-1

Manufactured No

190

Each

35.0000

4

4

**\*D3506-1\***

Doubler

\*\*

De 14/01/16

Location

Loc Qty

Loc Code

ST052

35

406261

30

88517

5

(4)

D3506-3

Manufactured No

190

Each

25.0000

2

2

**\*D3506-3\***

Doubler

\*\*

De 14/01/16

Location

Loc Qty

Loc Code

ST052

25

51790

25

(2)

MS20601-AD4W3

Purchased No

190

Each

1,380.000

12

12

**\*MS20601-AD4W3\***

Rivet

\*\*

De 14/01/13

Location

Loc Qty

Loc Code

ST311

500

114538

500

ST506

880

124331

600

124365

280

(12)



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Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

260

Each

469.0000

1

1

**\*AI S4-1032-225\***

Rivnut

**\*\***

ll 11/01/28

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

10

M127028

10

st555

429

M127092

429

x1

AN3C4A

Purchased

No

260

Each

2,777.000

31

31

**\*AN3C4A\***

Bolt

**\*\***

ll 11/01/28

Location

Loc Qty

Loc Code

FG

20

122814

20

ST513

2757

125388

1863

M127410

894

x31

AN3C5A

Purchased

No

260

Each

164.0000

2

2

**\*AN3C5A\***

Bolt

**\*\***

ll 11/01/28

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

159

m127290

159

x1128057

x2



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Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

76.0000

2

2

**\*AN526C1032R10\***

**\*\***

Screw

Location

Loc Qty

Loc Code

FP001

34

108062

34

ST346

42

m126857

42

D2965

Manufactured

No

260

Each

42.0000

1

1

**\*D2965\***

**\*\***

Cap

Location

Loc Qty

Loc Code

FP001

42

80089

11

99551

31

D2965-3

Manufactured

No

260

Each

15.0000

1

1

**\*D2965-3\***

**\*\***

Cap

Location

Loc Qty

Loc Code

FP001

15

98923

15

D3492-1

Manufactured

No

260

Each

195.0000

4

4

**\*D3492-1\***

**\*\***

Plug

Location

Loc Qty

Loc Code

FP001

195

104844

195

75  
1



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Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

260

Each

277.0000

4

4

**\*D3492-3\***

Plug

\*\*

ll 11/10/12

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

✓

D3492-7

Manufactured No

260

Each

117.0000

2

2

**\*D3492-7\***

Plug

\*\*

ll 11/10/12

Location

Loc Qty

Loc Code

FP001

117

106110

101

86759

16

✓

D3512-041

Manufactured No

260

Each

6.0000

\*\*

ll 11/10/12

**\*D3512-041\***

Wearplate Assembly

Location

Loc Qty

Loc Code

prelim

2

104832

2

ST500

4

109985

4

✓

D4918-047

Manufactured No

260

Each

2.0000

1

1

**\*D4918-047\***

Wearplate Assembly

\*\*

ll 11/10/12

Location

Loc Qty

Loc Code

prelim

2

109004

2

13109950

✓

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Start Qty: 1.00

Required Qty: 1.00

D4918-1      Manufactured      No

260      Each      4.0000      1      1

**\*D4918-1\***

**\*\***

Wearplate

Location

Loc Qty

Loc Code

prelim

4

109954

4

D4918-3      Manufactured      No

260      Each      4.0000      1      1

**\*D4918-3\***

**\*\***

Wearplate

Location

Loc Qty

Loc Code

prelim

4

109955

4

D4918-5      Manufactured      No

260      Each      4.0000      1      1

**\*D4918-5\***

**\*\***

Wearplate

Location

Loc Qty

Loc Code

prelim

4

109956

4

NAS1149C0332R      Purchased      No

260      Each      9,547.000      33      33

**\*NAS1149C0332R\***

**\*\***

WASHER

Location

Loc Qty

Loc Code

GA

1277

125654

1277

st510

8270

m126319

2770

m127306

2500

m127410

3000



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Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

366.0000

2

2

**\*NAS1611-007\***

O-RING

**\*\***

*all 1/10/13*

Location

Loc Qty

Loc Code

FP001

366

*103697*

366

*x2*

NAS1611-010

Purchased

No

260

Each

45.0000

4

4

**\*NAS1611-010\***

O-RING

**\*\***

*all 1/10/13*

Location

Loc Qty

Loc Code

FP001

45

*m126988*

45

*1127813*

*x4*

NAS1611-013

Purchased

No

260

Each

16.0000

4

4

**\*NAS1611-013\***

O-RING

**\*\***

*all 1/10/13*

Location

Loc Qty

Loc Code

FP001

16

*125445*

16

*11127813*

*x4*

AN3C4A

Purchased

No

280

Each

2,777.000

8

**\*AN3C4A\***

Bolt

**\*\***

DAS  
28  
9-89

*14-01-30*

Location

Loc Qty

Loc Code

FG

20

*122814*

20

ST513

2757

*125388*

1863

*M127410*

894

*8x*

DAS  
6  
9-89

DAS  
309

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Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

280

Each

9,547.000

8 8

**\*NAS1149C0332R\***

WASHER

\*\*

DAS  
28  
9-89

14-01-30

DAS  
6  
9-89

Location

Loc Qty

Loc Code

GA	1277	
125654	1277	
st510	8270	
m126319	2770	
m127306	2500	
m127410	3000	

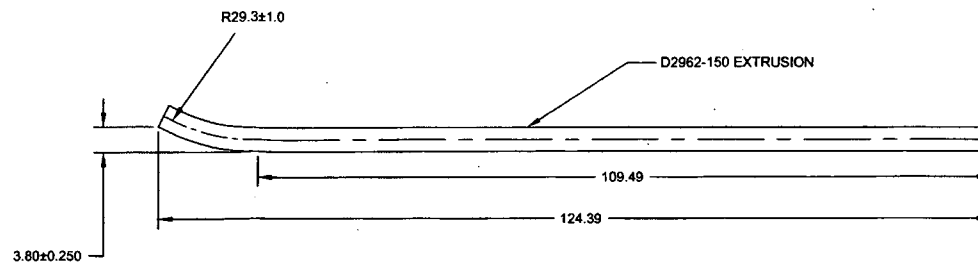
127831

DAS  
6

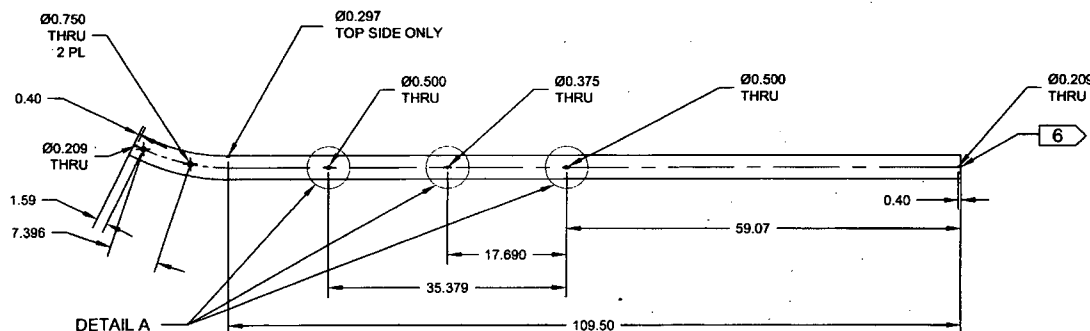
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

#### GENERAL NOTES:

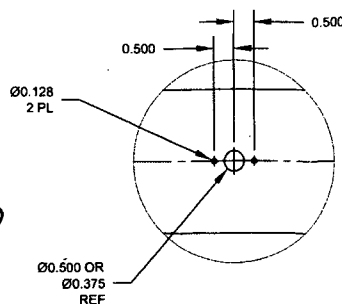
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.  
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



**D3507-1 BENDING/CUTTING DETAIL**



**D3507-1 DRILLING DETAIL**

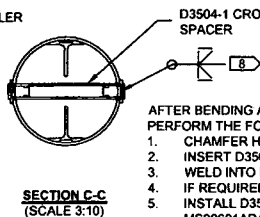
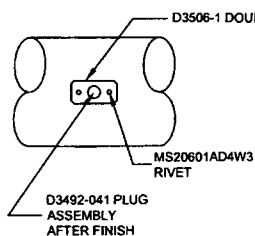


**DETAIL A**  
TYP. 6 PL  
SCALE 3:10

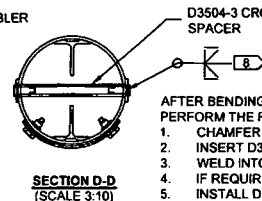
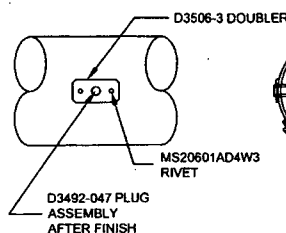
D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	DW		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



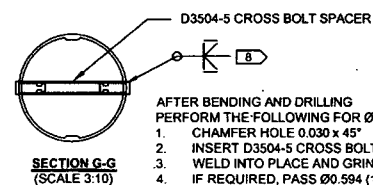
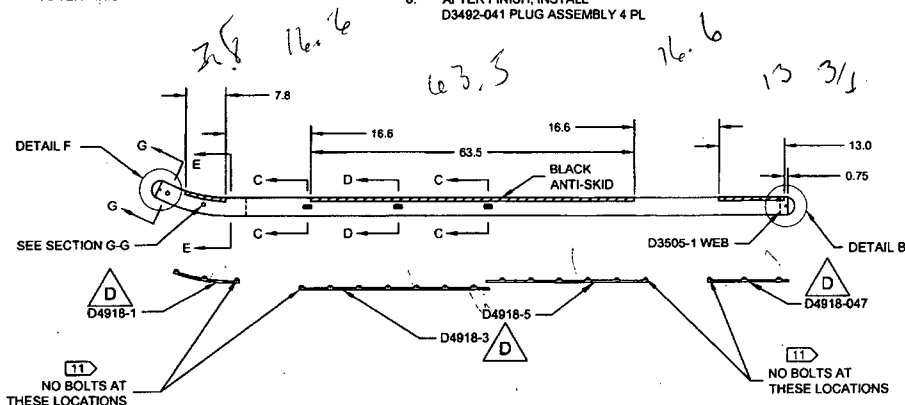




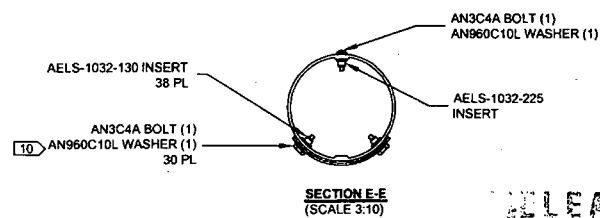
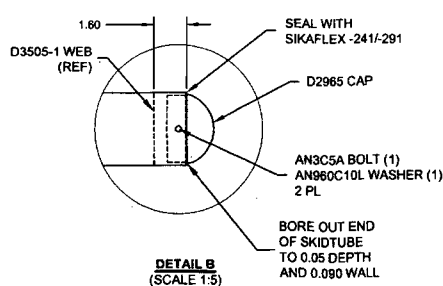
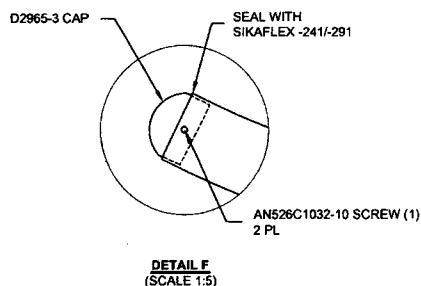
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.404 (Y DRILL) THRU HOLE
  5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
  6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.277 (J DRILL) THRU HOLE
  5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
  6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL



- AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
  5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



DESIGN	DW	<b>DART AEROSPACE USA, INC</b>	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	MP	D3507	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC	
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RELEASED  
2013-12-10



NO. 328

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: B105713  
Part #: A135-751-011  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Incomplete Penetration:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Incomplete Fusion:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Cracks:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ] fail[ ]
Burn through:	pass[ <input checked="" type="checkbox"/> ] fail[ ]

Qualifier David Hume Date of Test Coupon 13-09-18

Welder Barclay Elliott Date of Test Coupon 13-09-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 110471

December-20-13 9:06:48 AM

\*110471\*

Page 1

Item ID: D135-751-011

Accept

\*N19000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube (Fits LH or RH)

Stop \*NS2\*

Start Date: 12/20/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-12-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	DAS							
D3507	Rev <u>ED</u>	10 9-89							

100 0.00

ML5 14-01-30

\*100\*

DOCUMENT CONTROL

DC

Memo M.A.D. 0.00

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Photocopy bluefile & type labels per PPP D135-751-011 CHG002